

Work Order ID 57442

April 7, 2010 8:57:29 AM



Page 1

Item ID: DSK081

Revision ID:

Accept

Item Name: D2940-1 TURNING DETAIL

Start Date: 07/04/2010 Start Qty: 10.00

Required Date: 21/04/2010 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-11-06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSK081

Rev A

100



Doosan

Doosan Lathe

MORI SEIKI CNC LATHE LARGE

0.00

Memo

Turn blank as per Folio FA079

0.00

amt 10/04/11

10 0

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

amt 10/04/11

10 0

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

MV= 10/04/12

10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Packaging

Memo

Identify and Stock in Kanban Location: DSK 081

0.00

mmk 10/4/12

10

0

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/04/13

BS 10-4-13
(10)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April 7, 2010 8:57:34 AM

Work Order ID: 57442

Page 1

Parent Item: DSK081



Parent Item Name: D2940-1 TURNING DETAIL

Comments: IPP rev A. 08.03.13 new issue EC

Start Date: 07/04/2010

Required Date: 21/04/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6104-007		Manufactured	No				Each	20.0000	10.0000			



Round Billet, 17-4



Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

MAT43

20

53752

20

10 m/f 10/04/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	57442
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Prototype				
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.212	3.214	3.213	3.213	3.213
B	4.946	4.966		4.958	4.957	4.957	4.957	4.957
C	0.718	0.738		.726	.726	.726	.726	.726
D	0.090	0.110		.102	.100	.100	.101	.101
E	3.564	3.584		3.576	3.576	3.576	3.576	3.576
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.456	3.456	3.456	3.456	3.456
H	0.112	0.132		.122	.121	.122	.121	.121
I	2.170	2.190		2.179	2.179	2.180	2.179	2.179
J	4.451	4.471		4.465	4.463	4.464	4.463	4.463
K	0.413	0.433		.424	.423	.425	.426	.424
L	0.913	0.933		.922	.924	.923	.923	.925
M								
N								
O								
P								

Measured by	
-------------	--

Measured by:	<i>SM</i>	Date:	10/04/11
Audited by:	<i>MW</i>	Date:	10/04/12
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	57442
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

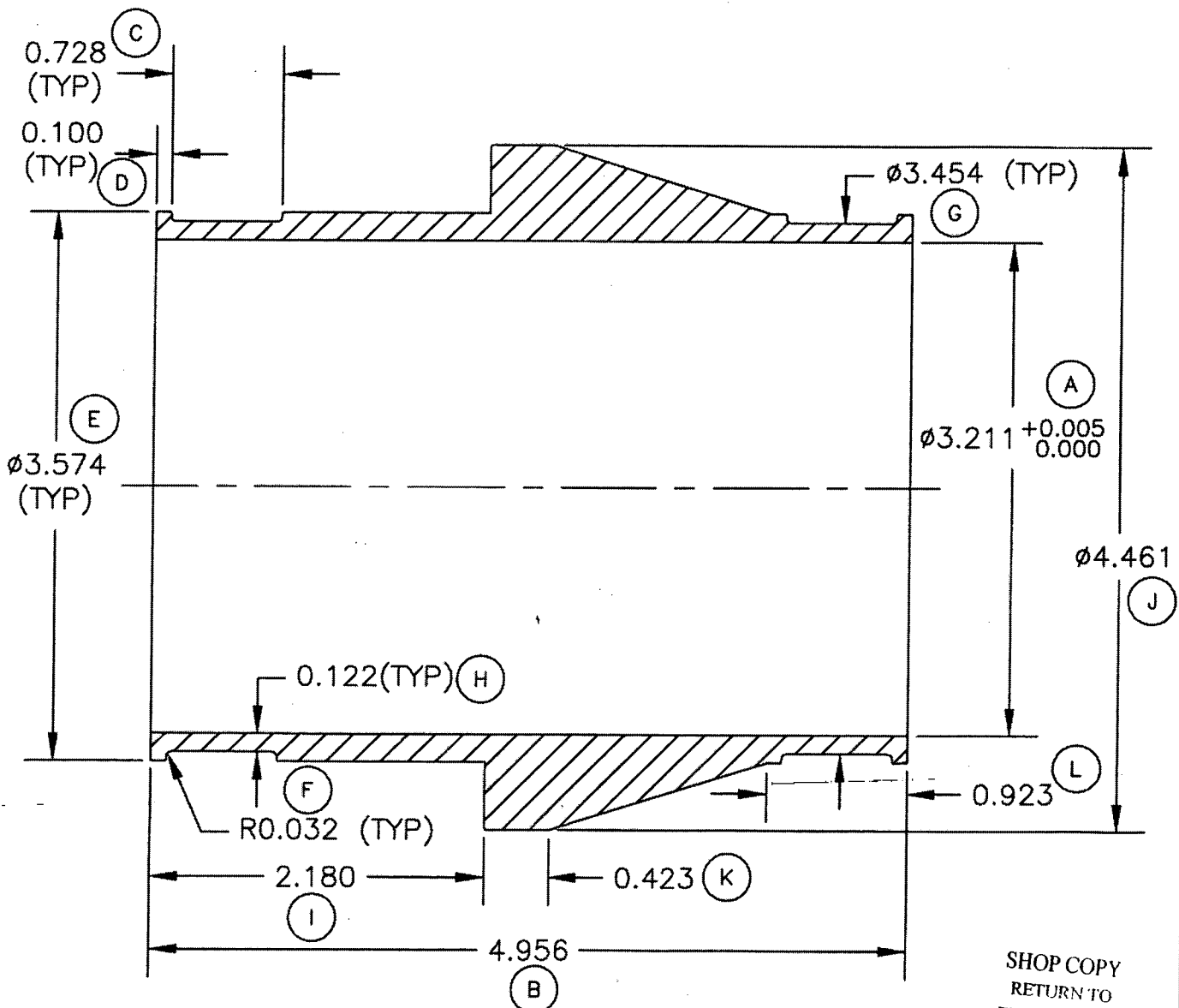
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
Lathe Section								
A	3.211	3.216		3.213	3.213	3.213	3.214	3.214
B	4.946	4.966		4.956	4.957	4.957	4.958	4.957
C	0.718	0.738		.724	.726	.724	.725	.726
D	0.090	0.110		.100	.100	.100	.100	.100
E	3.564	3.584		3.576	3.576	3.577	3.576	3.577
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.456	3.456	3.457	3.456	3.457
H	0.112	0.132		.121	.121	.122	.121	.122
I	2.170	2.190		2.179	2.180	2.179	2.179	2.179
J	4.451	4.471		4.463	4.463	4.463	4.463	4.463
K	0.413	0.433		.425	.424	.423	.425	.426
L	0.913	0.933		.923	.922	.920	.920	.923
M								
N								
O								
P								

Measured by:	cmf	Date:	10/04/12
Audited by:	MW	Date:	10/04/12
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	[Signature]

DART

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

RELEASED
03.07.01 [Signature]

D2940-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 574142
BJ 10-4-07

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